

Process Sheet

[illegible]

Comment: LANDING GEAR RESOURCE 1

- 1- Inspect mat'l D2500-1-190 for damage
- 2-Cut D2500-1-190 per Dwg D2580 if necessaryDeburr ends
- 3-Drill pilot holes using drill jig DT 8149
- 4-Acid etch and Alodine tube per QSI 005 4.1
- 5-Open holes to 0.500" as per Dwg D2580without cutting fluid

JD 7-6-26

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 2:10:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32973

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description:

6-Countersink holes as per Dwg D2580 without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 *M 164732*

Sikaflex expire date: *7-10-1*

Start Time: *2:30* Date: *7-6-27*

Fin Time: *11:20* Date: *7-6-28*

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

2-Drill extra fwd hole as per DEO 9183 using
drill jig DT8461

3-Drill extra middle hole as per DEO 9183 using
drill jig DT8462

4-Drill extra aft holes as per DEO 9183 using
drill jig DT8463 & DT8091

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

D25763

Step (Machining Detail)



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2576-3

Step

B29486 DE 07 07-2

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: D205-634-045 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 1 Date: 07/07/03
 QA: N/C Closed: 1 Date: 07/07/24

| NCR: <u>32973</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|---|----------------------|--|------------------------------|--------------------------------|--------------------------------|--------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07/07/03 | 4.9 | web was installed wrong, not lined up with the holes R.C. Human error. | <i>[Signature]</i> | see NCR 183 open holes horizontally 0.020" max. Debur, & tack-up with stichline. Test fit with pin. see attached email. | <i>[Signature]</i> 7-7-03 | <i>[Signature]</i> 07/07/12 | <i>[Signature]</i> 02/04/02 | <i>[Signature]</i> 07/07/03 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 2:10:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32973

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

24

D2579

Spacers

32026 BE 7-7-12

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

DP 7-7-12

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

m/04721 BE 7-7-12

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004. For D2579

spacers, weld one

side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

m/04721 BE 7-7-12

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

*****DO NOT COUNTERBORE EXTRA HOLES PUT IN AT STEP 13,14 AND 15 (LEAVE AT 0.384"Ø AS PER DEO 9183)****

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr

8-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/16

12.0

QC5

INSPECT WORK TO CURRENT STEP


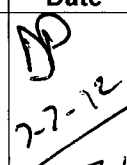

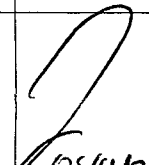
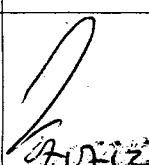
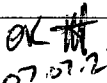
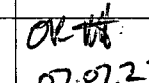


Comment: INSPECT WORK TO CURRENT STEP

07/07/16

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: D205-634-045 PAR #: N/A Fault Category: Prod - LG NCR: Yes No DQA: h Date: 07.07.20
 QA: N/C Closed: h Date: 07.07.24

| NCR: 32973 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------------|------|---|---|--|--|--|---|--|
| DATE | STEP | Description of NC Section A | Corrective Action | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07.07.12 | 10-3 | 1 x-bolt was not sitting center on the ridge. after welding & grinding. |  07.07.12 | Remove & replace x-bolt spacer - ensure to be centered on the ridge. |  07.07.12 |  07.07.16 |  07.07.23 |  07.07.12 |
| | | |  07.07.23 | | | |  07.07.23 | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 2:10:58 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32973

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

POWDER COATING

POWDER COATING



M 18144



Comment: POWDER COATING

Powder Coat ****GREEN****Sandtex (Ref: 4.3.5.8), as per QSI 005 4.3

BRM 07-07-16

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CUT 7/7/16 (1)

15.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D2577-1 | Wearplate | B31212 |

B31212

16.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 1 | D2577-3 | Wearplate | B 30551 |

B 30551

17.0

D25775

Wearplate, Centre



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 1 | D2577-5 | Wearplate | B 31251 |

B 31251

18.0

ALS71032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|---------------|-------------|----------|
| 44 | ALS7-1032-130 | Inserts | M 103495 |

M 103495

BRM 07-07-16 (1)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
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NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 2:10:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32973

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 4 AN960JD10L Washer

M103641

20.0

AN34A

Bolt



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number Description Batch

44 AN3-4A Bolt

M104817

21.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

plug

Batch: B32651

22.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

o-ring

Batch: B27168

23.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B33447

24.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M100188

07-07-16

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 2:10:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32973

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description:

25.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M103641

AB 07 07 - 160

26.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

M104616

Sikaflex expire date: 0709

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

M104616

Sikaflex expire date: 0709

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

M104733

Batch:

07/07/17

27.0

QC5

INSPECT WORK TO CURRENT STEP



En 07/07/17



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-045

Location:

PPP Rev:

PPP 33267 07/17/18

B 32973

29.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 07-12 AUTH

RELEASED DATE 07/21/18

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
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| | | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2580 | REV. C SHEET 1 OF 2 |
| DATE 98.08.26 | | TITLE 205 SKIDTUBE ASSEMBLY | SCALE NTS |
| A | 96.09.16 | NEW ISSUE | |
| B | 96.12.02 | AS MANUFACTURED | |
| C | 98.08.26 | REDRAWN, INCLUDED DEO 9094/9097 | |

RELEASED
98/09/17 DS

| QTY | Part Number | Description |
|-----|---|-------------------|
| X | D2580-041 | SKIDTUBE ASSEMBLY |
| * | D2500-1 | EXTRUSION |
| 1 | D2596 | 205 WEB |
| 1 | D2575 | AFT CAP |
| 1 | D2576 - 3 | STEP |
| 20 | D2579 | CROSS BOLT SPACER |
| 16 | D2594-1 | PLUG |
| 16 | D2594-3 | O-RING |
| 1 | D2577-1 | WEARSHOE |
| 1 | D2577-3 | WEARSHOE |
| 1 | D2577-5 | WEARSHOE |
| 44 | ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130 | INSERT |
| 46 | AN3-4A | BOLT |
| 46 | AN960JD10L | WASHER |

98.08.28
CP 08.08.28

EFFECTIVE DEOS
98/12/14
DEO 9124
DED 9/83

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES *
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32973

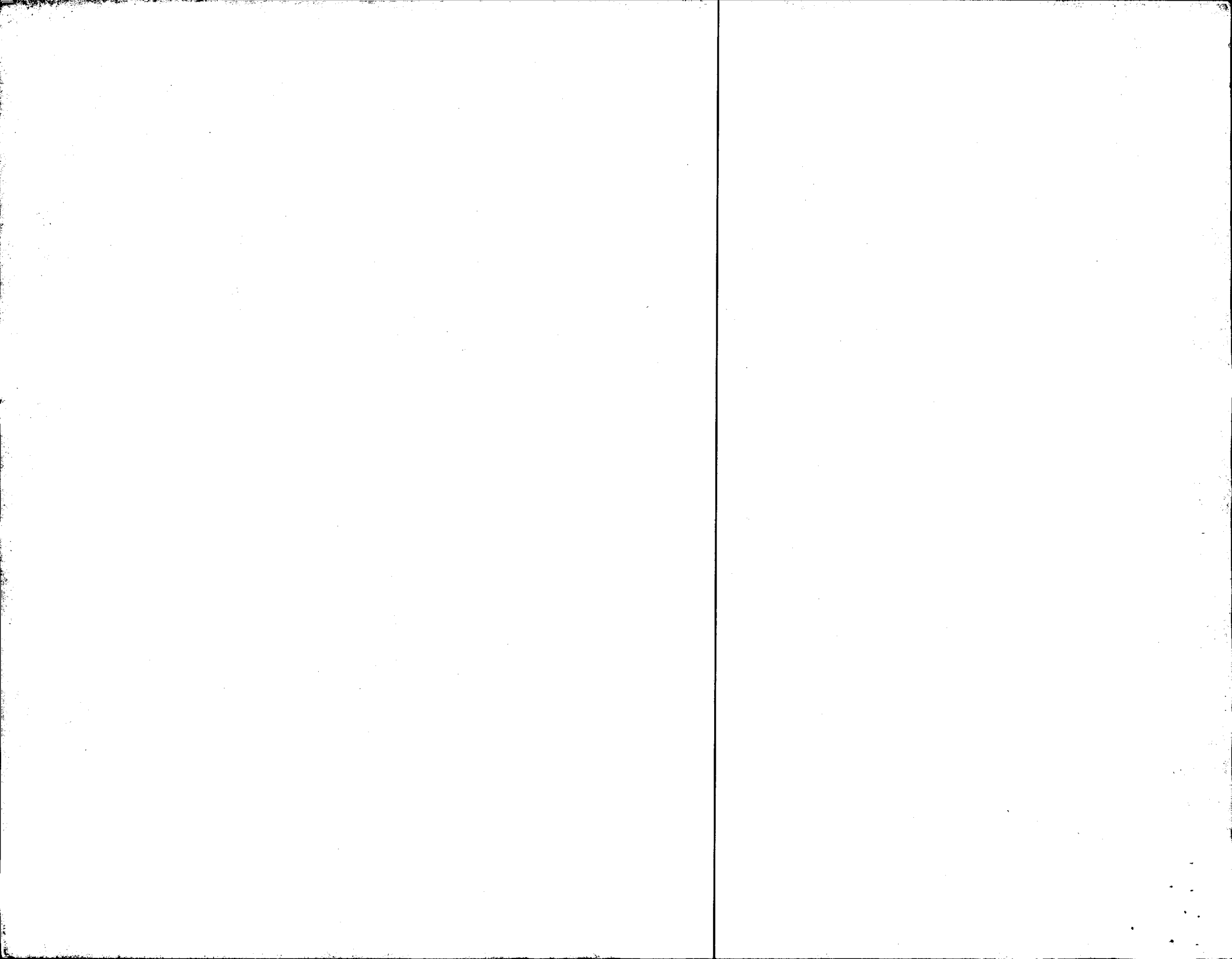


Diagram illustrating the grinding locations on a propeller cross-section. The diagram shows a cross-section of a propeller with the following labeled areas:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- GRIND FLUSH
- GRIND FLUSH

Technical drawing of a bolted joint assembly. The drawing shows a cross-section of a bolt and nut assembly. The bolt is labeled "AN3-4A BOLT (1)" and "AN96QJ10L WASHER (1) (2 PLACES)". The nut is labeled "D2575 CAP". The washer is labeled "D2575 CAP". The bolt is labeled "SEAL WITH SIKAFLEX-241". The drawing includes a dimension line indicating a distance of "0.40". The drawing is labeled "UNC SUB" in the bottom left corner.

DRILL PRIOR TO D2575 CAP
INSTALLATION (2 PLACES)

AN3-4A BOLT (1)
AN96QJ10L WASHER (1)
(2 PLACES)

D2575 CAP

SEAL WITH
SIKAFLEX-241

0.40

UNC
SUB

D2579 SPACER

WEB (REF)

-130 (REF)

4 PLACES

AFTER PERFORM


1. CHA
2. INS
3. WEI
4. C'B

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

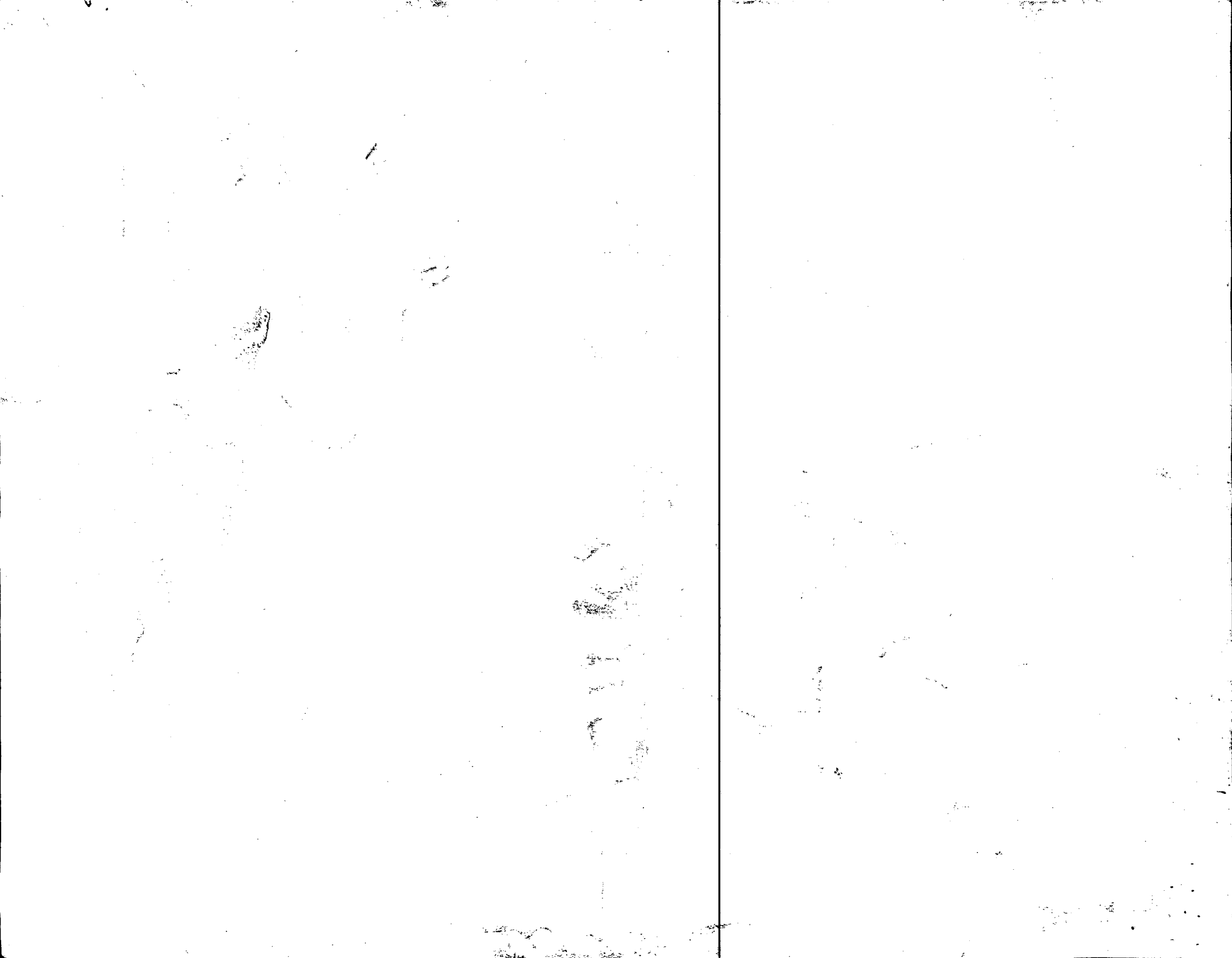
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO #0.437 X 1.00 DEEP

[illegible]

RELEASE
98/09/17 DS

| | | | |
|----------------------|-----------------------|---|---|
| DESIGN <i>DH</i> | DRAWN BY <i>CP</i> |  | DART AEROSPACE LTD HARRISBURY, ONTARIO, CANADA |
| CHECKED <i>DH</i> | APPROVED <i>JS</i> | | |
| DATE 98.08.26 | | TITLE 205 SKIDTUBE ASSEMBLY | SCALE 1:24 |

0.40
D:
ALST-
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
WITHOUT NOTICE
SUBJECT TO AMENDMENT
WORK ORDER
NO. 32973



DART

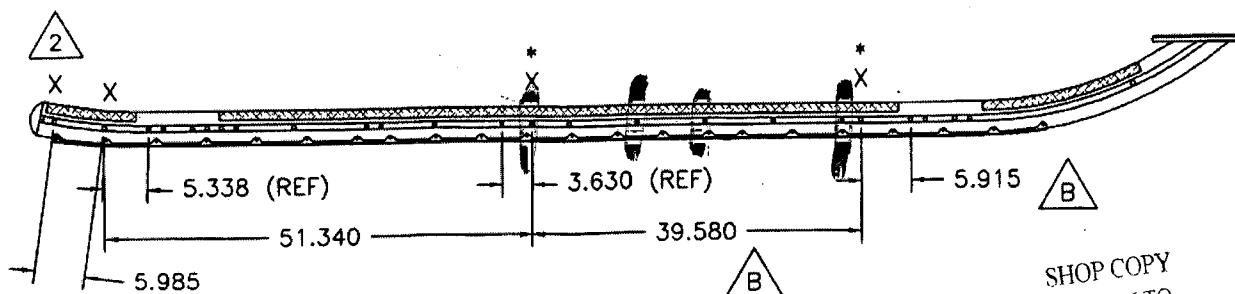
| | | | |
|------------------|----------------|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. DEO 9183 | REV. B SHEET 1 OF 1 |
| DATE 00.05.15 | | TITLE ADD SKIDTUBE P/N D2580-045 | SCALE NTS |
| A | 00.03.29 | NEW ISSUE | |
| B | 00.05.15 | 39.580 WAS 39.620 | |

DART ENGINEERING ORDER

AMEND DRAWING D2580 REV. C TO ADD D2580-045 ASSEMBLY

D2580-045 IS IDENTICAL TO D2580-041, EXCEPT FOR THE FOLLOWING CHANGES:

- 1) INSTALL CROSS BOLT SPACERS AT LOCATIONS MARKED 'X' ACCORDING TO THE FOLLOWING PROCEDURE.
 - a) DRILL $\varnothing 0.508$ HOLES AT LOCATIONS SHOWN BELOW MARKED 'X'.
CHAMFER HOLES $0.030 \times 45^\circ$. NOTE THAT HOLES WILL ALSO HAVE TO BE TRANSFERRED TO THE D2596 WEB AT THE * LOCATIONS. IT IS ACCEPTABLE TO PRE-DRILL THE D2596 WEB IN THESE LOCATIONS BEFORE INSTALLING THE WEB IN THE SKIDTUBE. OPEN HOLES TO $\varnothing 0.63$ AND TOUCH UP WITH ALODINE PER QSI 005 4.1.
 - b) INSERT D2579 CROSS BOLT SPACERS INTO THE HOLES.
 - c) WELD INTO PLACE PER DART QSI 004 AND GRIND FLUSH.
 - d) REMOVE SPILL OVER LEAVING HOLE DIMENSION $\varnothing 0.380$ - $\varnothing 0.390$.
- 2) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION.
- 3) POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 INSTEAD OF WHITE (REF. 4.3.5.1).



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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32973

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|------------------------|-------------------------|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. DSI 9184 | REV. A SHEET 1 OF 1 |
| DATE 00.03.29 | | TITLE ADD SKIDTUBE P/N D205-634-015 | SCALE NTS |
| A | 00.03.29 | NEW ISSUE | |

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. B.

REF. CANADIAN STA: SH96-88
US FAA STC: SR00563NY

ADD D205-634-015 INSTALLATION. PARTS LIST IS IDENTICAL
TO PARTS LIST FOR D205-634-011 EXCEPT THAT:
D205-634-045 REPLACES D205-634-041
D2580-045 REPLACES D2580-041

THE DIFFERENCE BETWEEN D205-634-011 (D205-634-041)
AND D205-634-015 (D205-634-045) IS THAT EXTRA
SPACERS HAVE BEEN ADDED AT LOCATIONS MARKED 'X' AND
ASSEMBLY IS PAINTED GREEN.

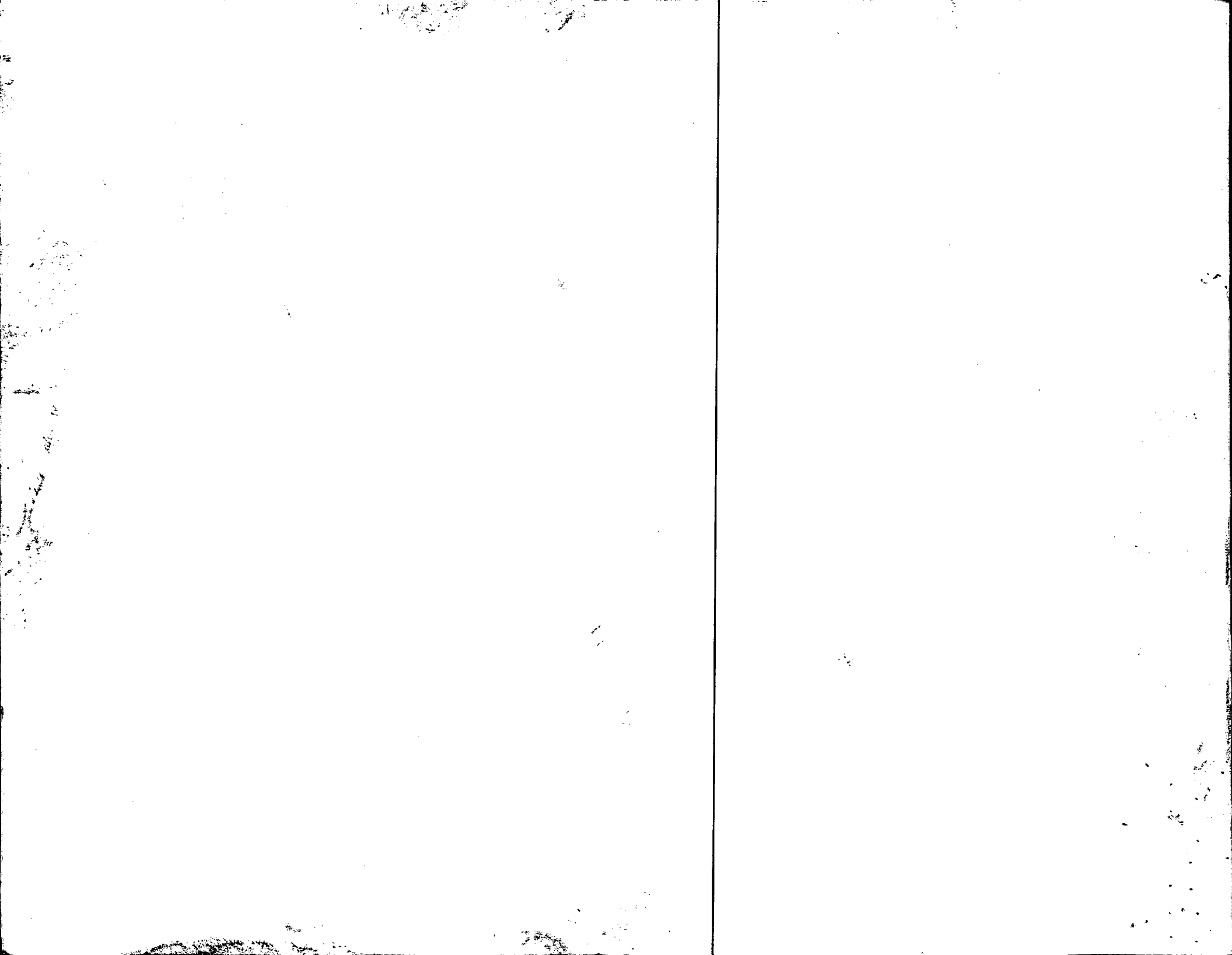


D205-634-015 (D205-634-045)

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32973

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NO. 116

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number 1205634041/B32617A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

| | Position | Vertical | Down <input type="checkbox"/> | Up <input type="checkbox"/> |
|--------------|-----------------------------|-----------------------------|-------------------------------|-----------------------------|
| Sheet Groove | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 3G <input type="checkbox"/> | 4G <input type="checkbox"/> |
| Tube Groove | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 5G <input type="checkbox"/> | 6G <input type="checkbox"/> |
| Sheet Fillet | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 3F <input type="checkbox"/> | 4F <input type="checkbox"/> |
| Tube Fillet | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 4F <input type="checkbox"/> | 5F <input type="checkbox"/> |

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/07/16 Qualifier Barclay Elliott

Jason Murdoch

From: David Shepherd [dshepherd@dartaero.com]
Sent: Tuesday, July 17, 2007 5:19 PM
To: 'L Lacelle'
Cc: 'Jason Murdoch'
Subject: RE: NCR for D205-634-045

It is acceptable to ovalize the holes in the WEB HORIZONTALLY BY 0.020" so that the crossbolt spacers can pass through the skidtube.

David

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Tuesday, July 17, 2007 8:24 AM
To: 'Jason Murdoch'; 'David Shepherd'
Subject: RE: NCR for D205-634-045
Importance: High

David,
These are ready to ship today, we would require an ok today.
Thx
Linda

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: July 6, 2007 7:42 AM
To: 'David Shepherd'
Cc: 'L Lacelle'
Subject: NCR for D205-634-045
Importance: High

Good day David. I have 4 skids that the webs were installed too far back resulting in an interference with the x-bolt spacers and the web. Especially, where the extra holes are. I would like to ovalize the hole vertically by 0.020". These webs were installed during the famous Dart black out last week, in the dark.

jmurdoch@dartaero.com
Q.C. COORDINATOR

No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.5.476 / Virus Database: 269.10.8/904 - Release Date: 7/16/2007 5:42 PM

No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.5.476 / Virus Database: 269.10.8/904 - Release Date: 7/16/2007 5:42 PM